



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.4001

Job Sheet 191680



Part No: 646.4001

Job Qty: 1 pcs

Part Name: AS350 Cable Cutter System



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/6/19

Job Tracking No:

Due Date: 4/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C1 IPP REV:A 12.10.23 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.08 AS PER DWG REV.B
DD VERF:JLM IPP REV:C 16.01.07 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	4/2/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

Dart Aerospace Ltd.
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CANADA
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Container No: S170831



Part: 646.4001

Job No: 191680

Serial No/Batch: S170831

Revision:

Inspector:

Exp Date:

Instructions: 09/06/2019 FAA STC SR02180LA 14/08/07vol 16 STC SH09 -

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120	QC 4	1 pcs	4/2/19	0.00 0.00	QC 4 - 26	
					QC 4 - 28	
					QC 4 - 42	
					QC 4 - 58	
					QC 4 - 6	
					QC 4 - 69	9-89 DAS 69
					QC 4 - 9	
					QC 4 - 46	
130	Packaging 3-1 - Stock - B4B	1 pcs	4/2/19	0.00 0.00	Packaging 3 - 1 - B4B	9-89 DAS 69
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
135	DC - 1 - B4B	1 pcs	4/2/19	0.00 0.00	DC - 1 - B4B	
					DC - 2 - B4B	APR 11 2019
140	QC 21 - FG	1 pcs	4/2/19	0.00 0.00	QC 21 - FG - 21	
					QC 21 - FG - 70	APR 11 2019 DAS 70
					QC 21 - FG - 53	9-89
Part Op 110 - pick kit						
Descriptions: 120 - QC4- 100% Inspect kits for completeness						
130 - Identify and pack for shipping as per PPP 646.4001 Location: _____						
135 - Document Control - Photocopy bluefile & type labels per PPP 646.4001						
140 - QC21- Final Inspection - Work Order Release						

008672

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.0129	VHB Tape	8 ft (8 ea)	110-Packaging 1 - Pick Kit	5158040
600.0990	Magnabond 6398 Part A Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5140436
600.0991	Magnabond 6398 Part B Size 112 ml	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5140437
600.1012	Sealant PR1425B2 (#654 sem) 05/19	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5133790
600.1013	021200-3M Tape Primer 94 Primer 24216	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5136734
646.2910	Deflector	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5154493
646.3001	Lower Cable Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5169545
646.3110	Channel	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5154342
646.3210	Support	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5091495
646.3301	Upper Cutter Assembly	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5159014
646.3510	Strut	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5127740
646.3511	Strut	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5127662
646.3610	Filler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5131480
646.3710	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5059684
646.3711	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5128060
646.3712	Clip	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5128050
646.3713	Gusset	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5124418
646.3714	Gusset	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5145099
646.3715	Strut Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5139095
646.3716	Gauge Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5063780
646.3717	Doubler	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5143796
646.3718	Custom Washer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5145123
646.3719	Doubler	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5143744
646.3810	Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5150081
646.3811	Radius Block	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5070843
646.3812	Gusset Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5150415
646.3813	AS350 Strut Bracket	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5131319
646.3910	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5128166
646.3911	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5133609
646.3912	Shim	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5124372
646.3913	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5041498
646.9410	Shim	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5056998
647.0112	Strut Bracket	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5133711
647.7703	Strut Assembly	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5162583
650.9201	Eyelet Bracket Assembly	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	x1 5131245
AN3-11A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5157480
AN3-12A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5133187
AN3-13A	Bolt	1 Ea (1 ea)	110-Packaging 1 - Pick Kit	5098032
AN3-3A	Bolt	4 Ea (4 ea)	110-Packaging 1 - Pick Kit	5131193
AN3-4A	Bolt	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	5149178
AN3-5A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5149158
AN3-6A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5103950
AN316C4R	Nut, Jam	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5133132
AN44-5A	Eyebolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5131191
AN4C7A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5071343
AN665-34R	Clevis	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5142141
CCR264SS3-02	Cherry Rivet	36 Ea (36 ea)	110-Packaging 1 - Pick Kit	5133149
CR3213-5-3	Cherry Rivet	14 Ea (14 ea)	110-Packaging 1 - Pick Kit	5140521
MS20426AD5-7	Rivet	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	F153848
MS20470AD5-5.5	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	FM134063
MS20470AD5-6	Rivet	8 Ea (8 ea)	110-Packaging 1 - Pick Kit	5048897
MS20470AD5-7	Rivet	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	F123425
MS21042L08	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5134219
MS21042L3	Nut	63 Ea (63 ea)	110-Packaging 1 - Pick Kit	5157462
MS21042L4	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5149814
MS21047-3	Nut Plate	18 Ea (18 ea)	110-Packaging 1 - Pick Kit	5152873
MS24693-C278	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5065341
MS24694-S51	Screw	5 Ea (5 ea)	110-Packaging 1 - Pick Kit	5133343 x3
MS24694-S54	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5152664

{Fridge}

5145508x1

5123459x2

5099526

5123937

5149665

5124664

5140520

5155664

5094554

5104011

5157648

5075330

5152652

5143716

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	600.0129	8	280	0
	600.0990	1	26	0
	600.0991	1	26	0
	600.1012	1	33	0
	600.1013	5	81	0
	646.2910	1	10	0
	646.3001	1	5	0
	646.3110	1	25	0
	646.3210	1	18	0
	646.3301	1	10	0
	646.3510	1	21	0
	646.3511	1	21	0
	646.3610	1	17	0
	646.3710	1	30	0
	646.3711	1	17	0
	646.3712	1	20	0
	646.3713	1	24	0
	646.3714	1	23	0
	646.3715	2	17	0
	646.3716	1	16	0
	646.3717	1	22	0
	646.3718	2	24	0
	646.3719	2	16	0
	646.3810	2	19	0
	646.3811	1	6	0
	646.3812	2	18	0
	646.3813	1	13	0
	646.3910	4	53	0
	646.3911	1	21	0
	646.3912	4	25	0
	646.3913	1	16	0
	646.9410	1	78	0
	647.0112	2	38	0
	647.7703	2	10	0
	650.9201	2	41	0
	AN3-11A	10	349	0
	AN3-12A	2	98	0
	AN3-13A	1	50	0
	AN3-3A	4	315	0
	AN3-4A	10	328	0
	AN3-5A	2	367	0
	AN3-6A	2	471	0
	AN316C4R	2	50	0
	AN44-5A	2	45	0
	AN4C7A	2	121	0
	AN665-34R	2	46	0
	CCR264SS3-02	36	1,063	0
	CR3213-5-3	14	259	0
	MS20426AD5-7	2	907	0
	MS20470AD5-5.5	8	985	0
	MS20470AD5-6	8	862	0
	MS20470AD5-7	3	85	0
	MS21042L08	2	1,885	0
	MS21042L3	63	3,960	0

MS21042L4	2	3,796	0
MS21047-3	18	363	0
MS24693-C278	5	141	0
MS24694-S51	5	227	0
MS24694-S54	2	169	0
MS24694-S55	3	188	0
MS27039-08-13	2	475	0
MS27039-1-10	2	531	0
MS27039-1-12	6	185	0
MS27039-1-16	24	1,280	0
MS27039-1-19	22	863	0
MS27039-1-20	2	78	0
MS27039-1-21	4	26	0
NAS1149F0332P	144	5,174	0
NAS1149F0363P	2	462	0
NAS1149F0432P	4	1,879	0
NAS1149FN832P	4	2,256	0

Part Specifications

Specifications could not be found.

Plex 3/6/19 10:59 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

50" WIDE
35A651.
IRFACES A/R BEFORE TAPE.
4216.
I BEST FITMENT.
5 BY MATCH DRILLING ON TO F/N 1.
INSTALLED ON AIRCRAFT. REMOVE
2E. MATCH DRILL HOLES. USE F/N 78

REFERENCE ONLY

UNINCORPORATED ECN(s)

05304

WITH UPDATED CANOPY MAY
USE F/N 62 TO REPLACE F/N 44 &
NECESSARY.

	5		5		5	78	601.3875	SCREW	MS24693C276	△	
	1		1		1	77	646.9410	SHIM	△		
			4		4	76	601.2764	WASHER	NAS1149FNB32P		
			2		2	75	601.2973	LOCKNUT	MS21042-08		
			2		2	74	601.2988	SCREW	MS27039-0813		
			2		2	73	601.2943	LOCKNUT	MS21042-3		
			2		2	72	601.3128	NUT	AN316C4R		
			2		2	71	601.3209	LOCKNUT	MS21042L4		
			4		4	70	601.2638	WASHER	NAS1149FD432P		
			2		2	69	601.2669	BOLT	AN4C7A		
			2		2	68	601.3119	CLEVIS	AN665-34R		
			2		2	67	601.3121	EYE BOLT	AN44-5A		
			2		2	66	650.9201	EYE BRACKET ASSY			
		REF	REF		REF	65	647.5701	GPS MOUNT KIT	△		
					2	64	601.3151	WASHER	NAS1149F0363P		
				2		63	601.2911	SCREW	MS24694553		
			24		24	62	601.2637	SCREW	MS27039-1-16		
	2		2		2	61	601.2763	BOLT	AN3-12A		
			1		1	60	646.3913	SHIM			
			4		4	59	646.3912	SHIM			
			1		1	58	646.3911	SHIM			
			4		4	57	646.3910	SHIM			
			5		5	56	600.1013	PRIMER			
			8 FT		8 FT	55	600.0129	VHB TAPE			
			1	1	1	54	600.1012	SEALANT	PR-1425 CLASS B		
			1		1	53	600.0991	MAGNOBOND 639B PART B	△		
			1		1	52	600.0990	MAGNOBOND 639B PART A	△		
	6		10		10	51	601.2826	BOLT	AN3-11A		
				2		50	646.3814	WIPER BRACKET			
				2		49	601.2910	SCREW	MS27039-1-18		
		2			2	48	601.1365	SCREW	MS27039-1-10		
		2			2	47	646.3719	DOUBLER			
			2		2	46	646.3718	CUSTOM WASHER			

			2		2	40	601.2031	RIVET
			1		1	39	646.3716	GAU
			6		6	38	601.1953	SCRE
		2			2	37	646.3715	STRU
			2		2	36	601.2824	BOLT
12		36			36	35	601.2277	RIVET
6		18			18	34	600.0795	NUTP
3		3			3	33	601.2565	RIVET
1		1			1	32	646.3813	STRU
4		4			4	31	601.2822	BOLT
2		2			2	30	646.3812	GUSS
8		8			8	29	601.2564	RIVET
1		1			1	28	646.3714	GUSS
	1		1		1	27	646.3610	FILLER
	3		3		3	26	601.2830	SCRE
	2		2		2	25	601.2825	BOLT
	1		1		1	24	646.3811	RADI
	1		1		1	23	646.3712	CLIP
	1		1		1	22	646.3711	CLIP
8		8			8	21	601.2832	RIVET
14		14			14	20	601.2020	RIVET
4	6	4	6		10	19	601.2823	BOLT
	1		1		1	18	601.2827	BOLT
	5		5		5	17	601.2912	SCRE
1		1			1	16	646.3713	GUSS
1		1			1	15	646.3210	SUPP
		1			1	14	646.3710	DOUB
	1		1		1	13	646.3110	CHAN
14	10	8	53	6	61	12	601.1624	LOCK
16	32	18	120	16	144	11	601.1607	WASH
				1		10	646.3410	LH WIF
				1		9	646.3411	RH WIF
			2		2	8	647.7703	STRU
			2		2	7	647.0112	STRU
	1		1		1	6	646.3511	STRU
	1		1		1	5	646.3510	STRU
2		2			2	4	646.3810	BRAC
			1		1	3	646.2910	DEFLE
	1		1		1	2	646.3001	LOWE
			1		1	1	646.3301	UPPER
							646.4006	LOWER
							646.4005	PROVIS
							646.4004	PROVIS
							646.4003	FIXED
							646.4002	CABLE
							646.4001	AS350
							646.4001	AS350
.4006	.4005	.4004	.4003	.4002	.4001	FIND #	PART #	DI

REFERENCE ONLY

QTY	PA
NEXT ASSY (S)	ORIGINAL DATE 08-27-08
	DRAWN BY S. HUFF
	CHECKER P. BRAVO
	DRAWING APPROVAL